

Date: Monday, 3/26/2007 1:02:38 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUIDE
Job Number	: 31480		
Estimate Number	: 12807		
P.O. Number	: N/A	Part Number	: D35713
This Issue	: 3/26/2007 S.O. No. : N/A	Drawing Number	: D3571 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: AC0002
First Issue	: N/A	Drawing Revision	: U/R
Previous Run	: N/A	Material	: N/A
Written By	: <u>07-03-26</u>	Due Date	: 4/2/2007
Checked & Approved By	:	Qty:	5 Um: Each
Comment	: Est Rev:A New Issue 07-02-01 JLM		

Additional Product

FOR ENGINEERING USE ONLY

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0750X01000 6061-T6 Bar .75" x 1.0"



Comment: Qty.: 0.2531 f(s)/Unit Total : 1.2653 f(s)

6061-T6 Bar .75" X 1.0"

Batch: M158759 07-03-26 6

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank 2.90" long

59 07-03-26 6

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA681 Rev: A & Dwg D3571 Rev: A

2-Deburr per dwg D3571

59/07 07/03/27 6

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

59/07 07/03/27 6

5.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1-C'SINK PARTS AS PER DWG D3571

2-Chamfer inside 1/8" slot using Dovetail cutter

9mk 07/03/27 6

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 31480

Part Number: D35713

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

9-26 07/03/27

6

7.0

QC8

SECOND CHECK



see Lesne

**ENGINEERING
APPROVAL**

UE 07.03.27



Comment: SECOND CHECK

07.03.27 J.L.

07/03/27

6

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

POWDER COATING

POWDER COATING



N/A
07.03.27



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

UE 07.03.27

change to 00604

12.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/27

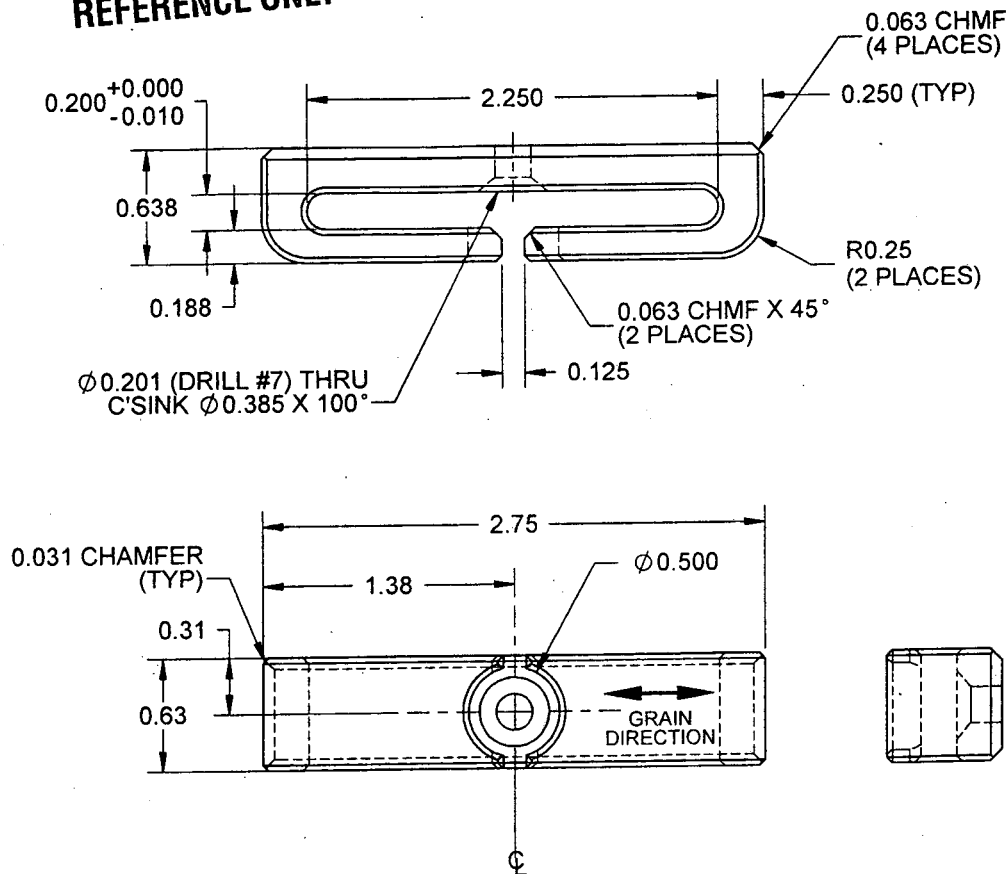
Job Completion



U 07.03.27

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JH</i>	APPROVED <i>H</i>	DRAWING NO. D3571	REV. A SHEET 2 OF 2
DATE 07.01.29	TITLE GUIDE		SCALE 1:1

REFERENCE ONLY**D3571-3 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ

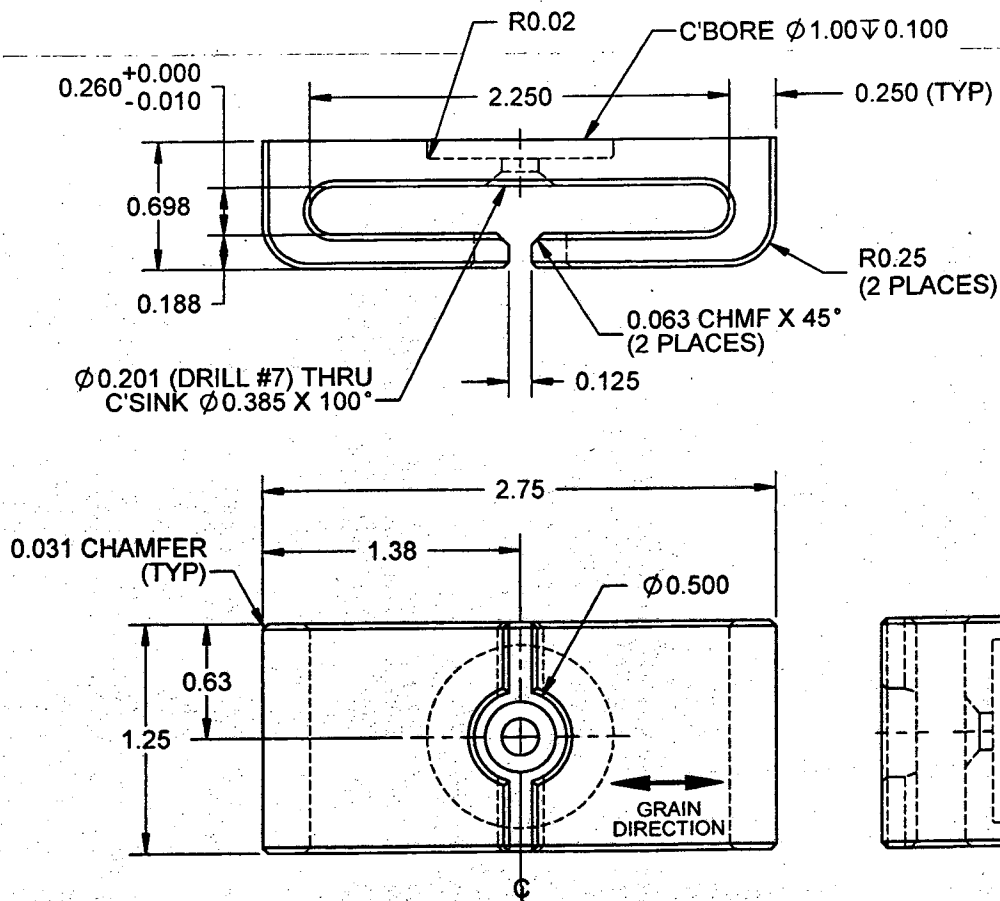
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DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A SHEET 1 OF 2
DATE 07.01.29		TITLE GUIDE	SCALE 1:1
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	

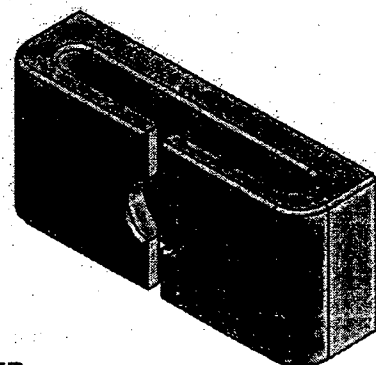
REFERENCE ONLY



D3571-1 GUIDE

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
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OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
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- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT CL



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